

Date: Wednesday, 3/29/2006 1:04:24 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350/212/130 BASKET LID	
Job Number :	26390B			
Estimate Number :	10193			
P.O. Number :	N/A	Part Number :	D2512	
This Issue :	3/29/2006	Drawing Number :	D2512 REV D2	
Prsht Rev. :	NC	Project Number :	N/A	
First Issue :	N/A	Drawing Revision :	D2	
Previous Run :	26149B	Material :	N/A	
Written By :	<u>SEE COMMENT BELOW</u>		Due Date :	4/5/2006
Checked & Approved By :	<u>W</u>		Qty:	1 Um: Each
Comment :	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 45.7594 f(s)/Unit Total: 45.7594 f(s) ~~M100282~~ M19557 → 61.68"
 Pick: CPL 06.03.29
 3/4"x3/4" 304/316 SS tube .063" wall
 Batch: M100023 → 190.6" M100282 → ~~174.36"~~

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch 325896
 1 D3166-3 Basket Hoop ~~M100023~~ CPL 06.03.30

3.0	D2506	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D2506 Label Plate 324875 CPL 06.03.30

4.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2327-1 Bushing 824873 CPL 06.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/29/2006 1:04:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 26390B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2232-1 Hinge plate

Batch

B23445

CPL 06-03-30

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch

B25834

CPL 06-03-30

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description
18 sf M304EX0.75-16F Expanded Metal

Batch

M100518

CPL 06-04-04

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

~~4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.~~

~~EC130 Basket only~~

~~Pick:~~

~~Qty Part Number Description Batch~~

~~2 D2012-117 Clevis~~

N/A

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

CPL 06-04-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/29/2006 1:04:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 26390B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/04/10

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/04/11 (1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 118850 / 119640 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/04/11

Job Completion



Level 21 inspection 06/04/18 (1)

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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